

Work Order ID 162834

Thursday, June 15, 2017 2:31:31 PM

162834

Page 1

Item ID: D3954-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chain Lug

Start Date: 6/12/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/15/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:  Date: JUN 16 2017

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3954	D								

100

0.04

100

Mill Conv

Memo

2.52

Conventional Milling Machine

mill to size

6

DAS
32
9-89

17-07-10

110

0.00

110

Waterjet

Memo

1.72

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: 9Prog Rev: P

2-Deburr if necessary



a 17/06/22

Thursday, June 15, 2017 2:31:31 PM

Page 2

[illegible]

Work Order ID 162834

Thursday, June 15, 2017 2:31:31 PM

162834

Page 3

Item ID: D3954-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Chain Lug
Start Date: 6/12/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
140									
Packaging	Memo	0.06				(6)		DYC	
Packaging	LOCATION: WA002							17/07/13	
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.60							17/7/17
Quality Control									

(10) JUL 13 2017

Picklist Print

Thursday, June 15, 2017 2:31:31 PM

Page 1

Work Order ID: 162834

162834

Parent Item: D3954-5

D3954-5

Parent Item Name: Chain Lug

Start Date: 6/12/2017

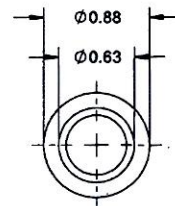
Required Date: 6/15/2017

Start Qty: 6.00

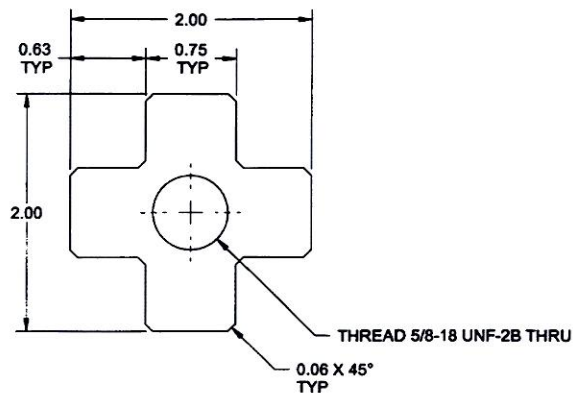
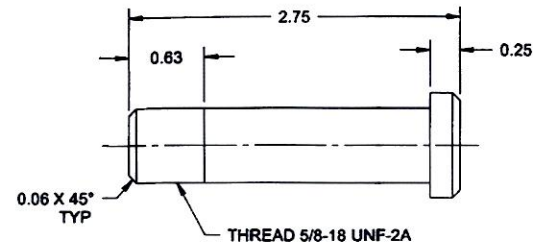
Required Qty: 6.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

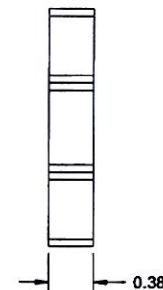
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X2.000		Purchased			No	100	f	13.5710	0.5	3.157895			
M303B1 000X2 000									**	3.171		06/17/2017	
303 BAR 1" X 2"													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT008		13.571							
				m125822		12				1.6			
				m128503		1.571				1.571			



D3954-1 GWT PIN



D3954-3 GWT KNOB

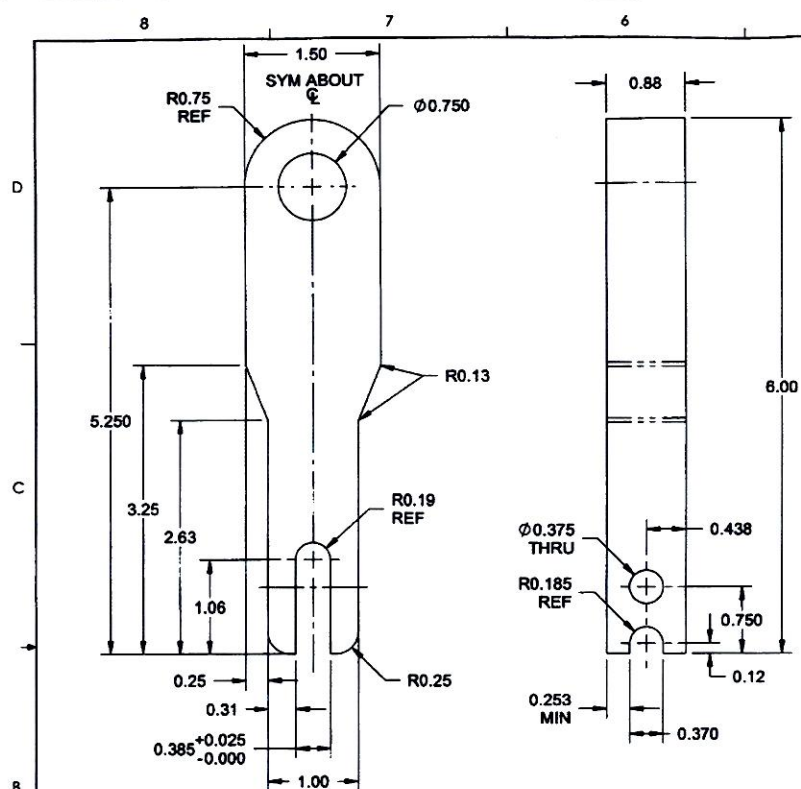


NOTES:

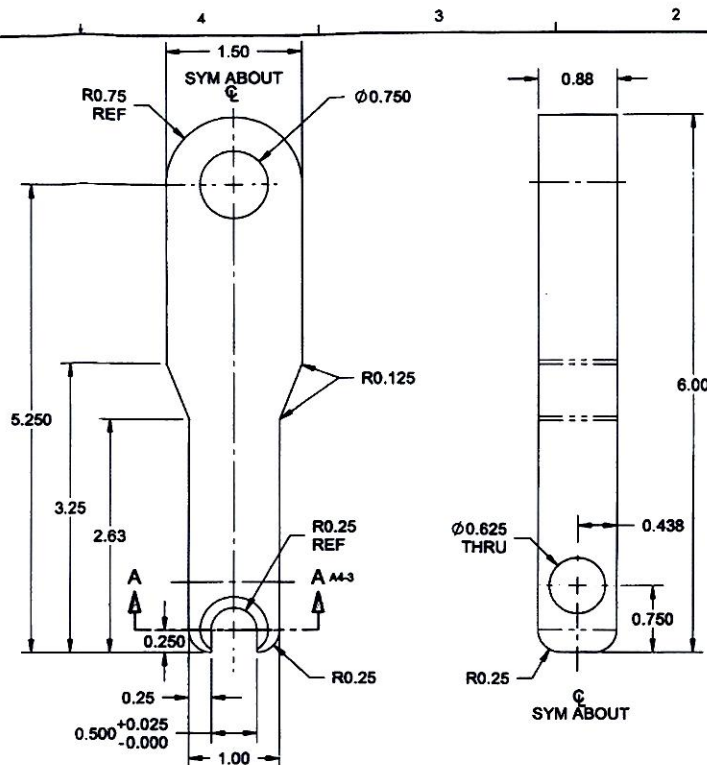
- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
- 3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2012-10-01

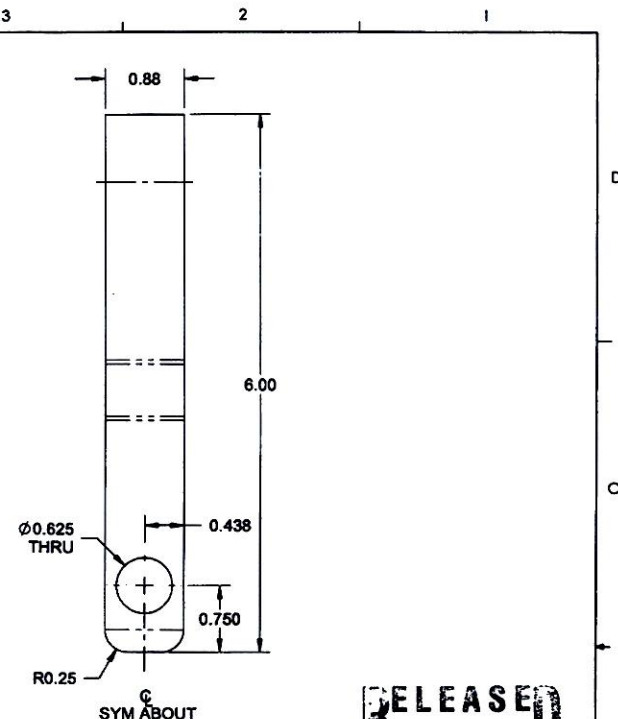
DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3954	SHEET 2 OF 3
APPROVED	BC	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	12.08.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



D3954-9 GWT CHAIN PIN

NOTES:

1) MATERIAL:

- 5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B
- 9: PURCHASE PART FROM MCMaster-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

- 5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 9: PURCHASE PART FROM MCMaster-CARR:
P/N 90145A630 (STAINLESS STEEL)

**2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3**

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

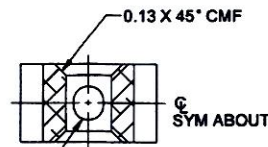
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

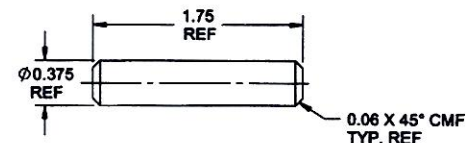
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1

7) WEIGHT -5/-7: 1.58 lbs EACH

-9: 0.05 lbs REF



SECTION A-A C3-3



DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. D
MFG. APPR.	JS	D3954	SHEET 3 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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